

Date: Monday, 02/02/2009 3:49:09 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BASKET LID ASS'Y (A119)
Job Number : 45428A	
Estimate Number : 12445	
P.O. Number :	Part Number : D3515041
This Issue : 02/02/2009 S.O. No. :	Drawing Number : D3515 REVA
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : LARGE FAB ASSY	Drawing Revision : A
Previous Run : 45427A	Material :
Written By :	Due Date : 01/04/2009 Qty: 1 Um: Each
Checked & Approved By : <u>JUD 09.02.03</u>	
Comment : EST rev. A 06.06.05 Preliminary EC est B 07.04.09 revA dwg EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D22321	Basket Hinge
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Basket Hinge

Batch: B46709

D 09.04.15

2.0	D31663	Basket Hoop
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Basket Hoop

Batch: 46623

SAD 09-04-14

3.0	D23271	Spacer Bushing
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Spacer Bushing

Batch: B46325

D 09.04.15

4.0	D2506	Label Plate
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Placard

Batch: B44275 → 1x

LM 09/04/22

5.0	D2581	Mounting Bracket
-----	-------	------------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Mounting Bracket

Batch: B45684

D 09.04.15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

✓ 6.0 M304TS0750W065 304 SQ Tube .75x.75x.065W



Comment: Qty.: 43.5750 f(s)/Unit Total : 43.5750 f(s)

AISI 304 SQ Tube.75x.75x.065W

Batch: M111331

SAD 09-04-15

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Cut rib D3515-1 (2) as per dwg D3516

SAD

09-04-15

2-Cut rib D3515-3 (2) as per dwg D3516

SAD

09-04-15

3-Cut rib D3515-5 (6) as per dwg D3516

SAD

09-04-15

4-Cut rib D3515-7 (3) as per dwg D3516

SAD

09-04-15

5-Cut Rib (4) D2236 from D3166-3 per dwg D2236

SAD

09-04-15

①

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld assembly as per dwg D3515

① 09-04-15 ①

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

① 09-04-15

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

① 09/04/15 ①

✓ 11.0

M304EX07516F

Expanded Metal Flat SS



Comment: Qty.: 21.0000 sf(s)/Unit Total : 21.0000 sf(s)

Expanded Metal Flat Stainless steel

Batch: M111444(19) M111173(2)

SAD

09-04-21 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 45428A

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Job Number:



Seq. #: Machine Or Operation: Description :

12.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut expanded metal for base as per dwg D3516

2-Cut expanded metal for base ends as per dwg D3516

3-Weld expanded metal to base as per dwg D3516

SL 09/04/22 (1)

13.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

CPC09.0423

14.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/04/23 (10)

15.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

Pressure wash CND/BR.

09/04/24 (1)

M 110939

1ST COAST:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

***** 2nd coat if necessary*****

2ND COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

*3:15
400°
3:45*

BR 09-04-27 (1)

*8:15
400°
8:45*

BR 09-04-28 (1)

16.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 09/04/28 (1)

17.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: Wing Walk as per Dwg D3515 and QSI 005 4.4 and spray paint as per dwg

wing walk:

black spray paint:

M 11/013

M 11/0907

FL 09/04/28 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

8.0264129 @

19.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

PP P45428

8.09/04/29 @

20.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/01/30 @

Job Completion



mf 09-04-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

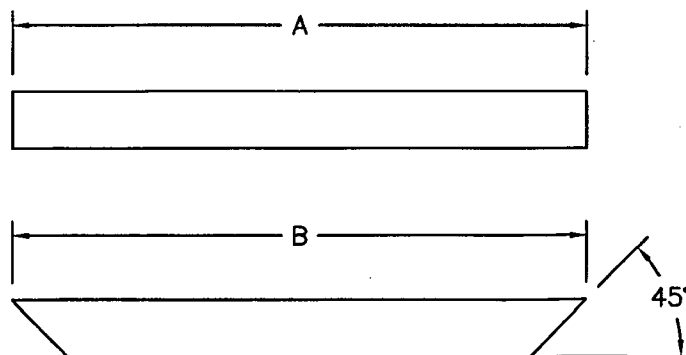
NOTE: Date & initial all entries

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3515	REV. A SHEET 1 OF 4
DATE 06.05.05		TITLE BASKET LID ASSEMBLY (A119)	SCALE NTS
A	06.05.05	NEW ISSUE	

RELEASED06.11.17 *[Signature]***PARTS LIST FOR D3515-041 BASKET LID ASSEMBLY**

PART NO	QUANTITY	LENGTH	LENGTH	DESCRIPTION
		A	B	
D3515-1	2	—	25.50	RIB
D3515-3	2	—	101.30	RIB
D3515-5	6	33.84	—	RIB
D3515-7	3	30.63	—	RIB
D2232-1	2	N/A	N/A	HINGE PLATE
D2236	4	N/A	N/A	RIB
D2327-1	2	N/A	N/A	BUSHING
D2506	1	N/A	N/A	LABEL PLATE
D2581	2	N/A	N/A	MOUNTING BRKT

**D3515-1/-3/-5/-7**

- 1) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
- 2) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING
(REF. DART SPECS. M304TS0.750W.065)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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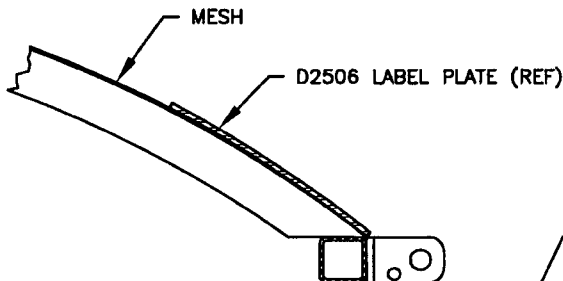
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06.11.17



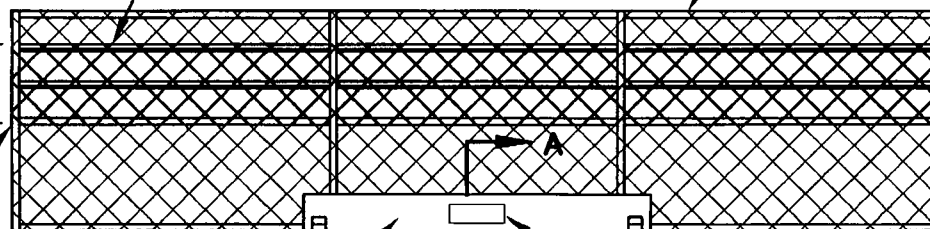
SECTION A-A
(ROTATED 90° CCW)

FINISH THIS SECTION ALONG
ENTIRE LENGTH PER NOTE 3
AFTER POWDER COAT

TACK WELD MESH TO
FRAME AT EVERY AVAILABLE
LOCATION IN AREA TO BE
ANTI SKIDDED

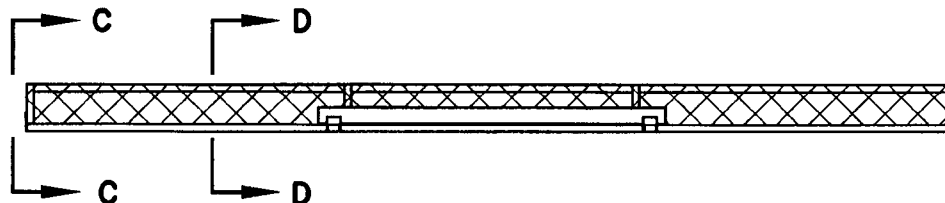
SKIN OUTSIDE SURFACE OF LID WITH
3/4-16F EXPANDED SS. TACK WELD
EACH END STRAND TO FRAME

SEE DETAIL B FOR
FRAME ASSEMBLY



D2506 LABEL PLATE
CENTER ON THE BASKET

REMOVE 2" X 6" SECTION
OF MESH FROM BEHIND
LABEL PLATE



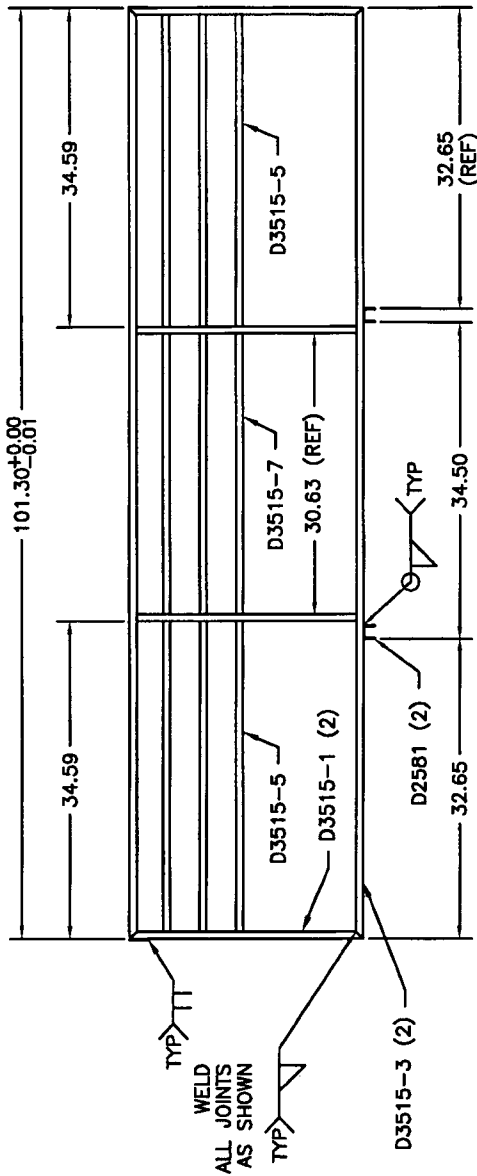
D3515-041 BASKET LID ASSEMBLY

- 1) MESH MATERIAL: 3/4-16F EXPANDED SS (REF. DART SPEC. M304EX0.75-16F)
- 2) WELD PER DART QSI 004
- 3) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 4) SPRAY PAINT BLACK INSIDE SURFACE
APPLY BLACK ANTI-SKID TO OUTSIDE SURFACE PER DART QSI 005 4.4
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

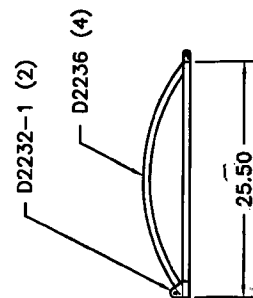
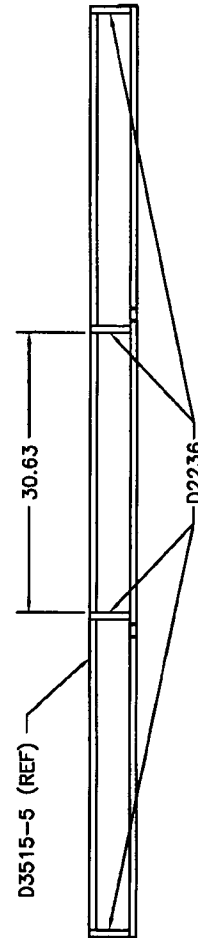
DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
DATE	TITLE	REV. A
06.05.05	BASKET LID ASSEMBLY (A119)	SHEET 2 OF 4
		SCALE
		1:20



DESIGN B	DRAWN BY B	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3515	REV. A SHEET 3 OF 4
DATE 06.05.05		TITLE BASKET LID ASSEMBLY (A119)	SCALE 1:20



DETAIL B
FRAMEWORK SHOWN FOR CLARITY
TOLERANCES ARE PER DART QST 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES



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(CONTROLLED COPY)
ELECT TO ANY COMMENT
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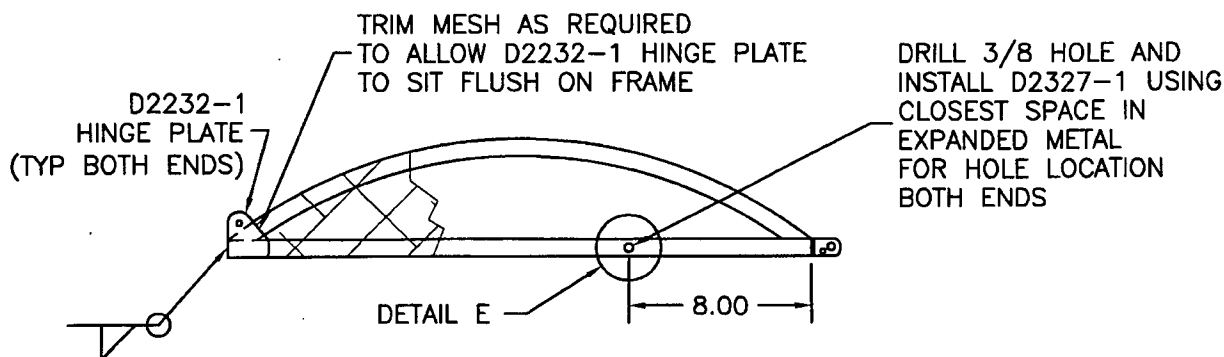
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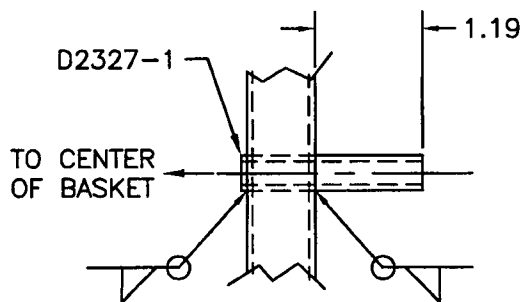
DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3515	REV. A SHEET 4 OF 4
DATE 06.05.05		TITLE BASKET LID ASSEMBLY (A119)	SCALE 1:8



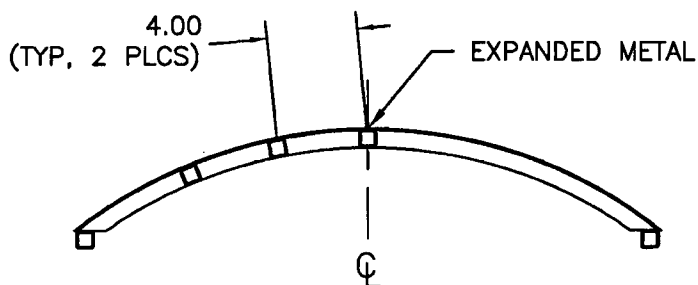
SECTION C-C SIMILAR BOTH END RIBS

RELEASED

06-11-07



DETAIL E



SECTION D-D SAME BOTH CENTER RIBS

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